

Date: Friday, 02/11/2007 1:53:51 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 35509		
Estimate Number	: 10774		
P.O. Number	: <u>N/A</u>	Part Number	: D3414041
This Issue	: 02/11/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3414 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 34953	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 09/11/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	20 Um: Each
Comment	: Est A 05.09.13 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S12GA	304/316 .100" Sheet
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3.5029



Comment: Qty.: 0.1523 sf(s)/Unit Total : 3.0450 sf(s)

304/316 stainless steel 0.100" Sheet

Batch: 105130 IB 07-11-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3414

Dwg Rev: AProg Rev: AIB 07-11-6

23
 22

2-Deburr if necessary

IB 07-11-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-11-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

3 counts
07-11-07 23 22

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr

Form using DT8254 as per Dwg D3414

SAD 07-11-04

IB 07-11-30 23 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY

Job Number: 35509

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 07/12/03 (22)

7.0

D34143

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Lug

Pick:

Qty Part Number Description Batch

1 D3414-3 Lug

A/R SS Rod

B33950

M102421

FC 07/12/03 (22)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

FC 07/12/03 22

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

FD 07-12-04 (22)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

only 22 were made. the 23's was
identified B33509 D3414.

FC 07/12/04 (22)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105914

BR 07-12-05

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/P 07/12/05 22X

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST475

FC 07/12/07

(22)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-7	2	3 PART LIFTED AND GOT CUT BY NEXT PIECE <i>RE</i>	<i>JB</i> <i>07/11/07</i>	SCRAP and destroy and replace	07-11-7 <i>JB</i>	<i>S</i> <i>Atub7</i>	<i>JB</i> <i>07/11/07</i>	<i>S</i> <i>07/11/07</i>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 35509

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LD 02/12/07

Job Completion



W 02.12.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

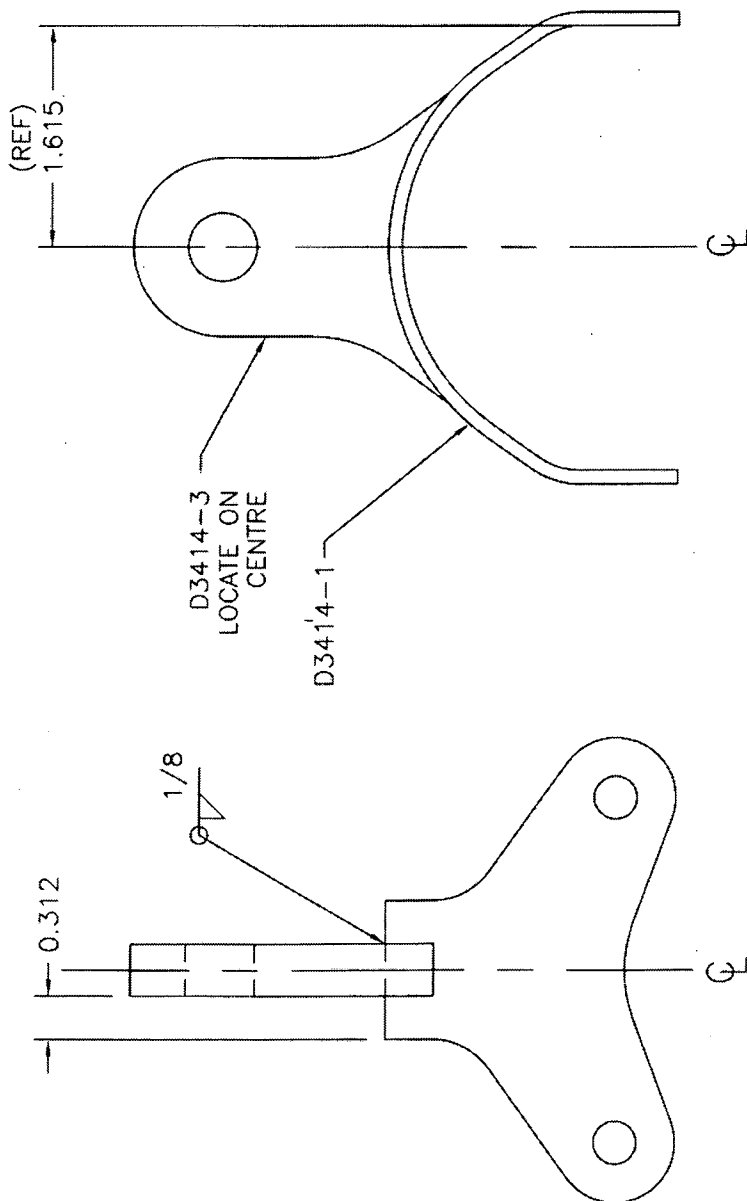
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 1 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE NTS
A	05.03.16	NEW ISSUE	



D3414-041 LUG ASSEMBLY

- 1) WELD PER DART QSI 004
2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) PART IS SYMMETRIC ABOUT CENTERLINE

W/ 35509

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

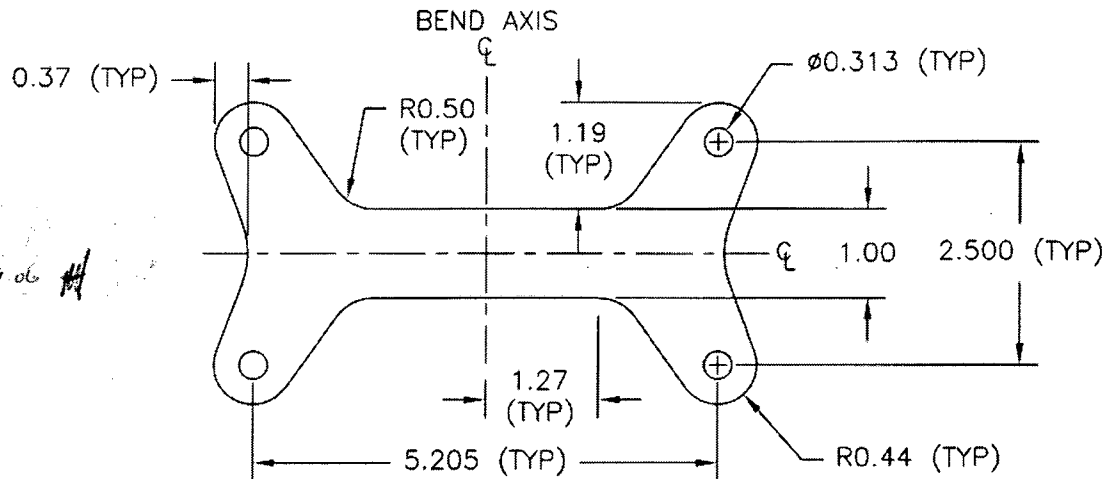
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

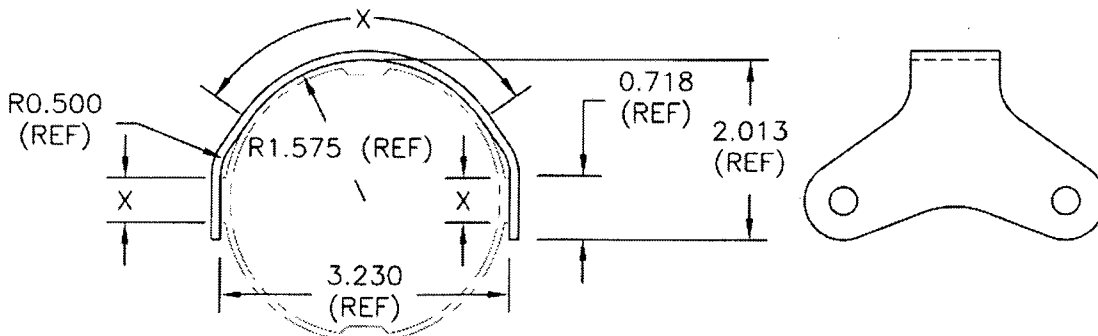


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 2 OF 3
DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:2



D3414-1 FLAT PATTERN

SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D3414-1 BEND DETAIL

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3414-1 LUG BRACKET

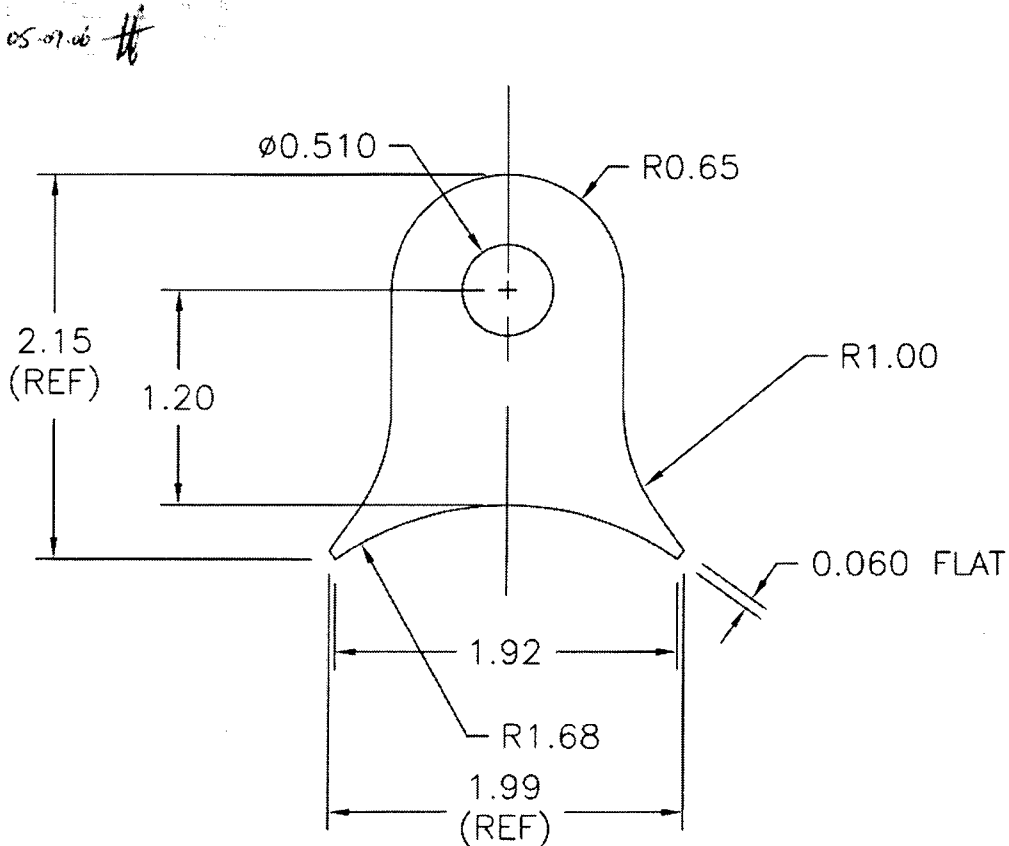
- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 3 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:1



D3414-3 LUG

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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